

Del. 2.00

Work Order ID 69386

Tuesday, May 10, 2011 2:26:02 PM



Page.1

Item ID: D2813

Accept



Setup Start



Revision ID:

Stop



Item Name: Washer

Start Date: 5/10/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-05-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2813

Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA637 & DWG D2813, □FOLIO
REV: *[Signature]* □DWG REV: *[Signature]* □2-DEBURR AS REQUIRED

SA 11/5/25

21 *[Signature]*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 11/5/25

21 *[Signature]*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

29 11.5.25

21 *[Signature]*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69386

Tuesday, May 10, 2011 2:26:03 PM



Page 2

Item ID: D2813

Accept



Setup Start



Revision ID:

Stop



Item Name: Washer

Start Date: 5/10/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location 023

0.00



Packaging

Memo

0.00

Packaging

Ref 26 *01*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/26
MF
11-05-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 10, 2011 2:26:10 PM

Page 1

Work Order ID: 69386

Parent Item: D2813

Parent Item Name: Washer



Start Date: 5/10/2011

Required Date: 5/12/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:C Now Turned 06-02-24 JLM
IPP Rev:B 00.11.16 Changed material EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDELRINR2.000 Purchased

No

100

f

19.3100

0.016

0.336842



5/12/2011

DELRIN ROUND BAR 2.00"

Location

Loc Qty

Loc Code

MAT050

1.31

117586

1.31

MAT055

18

104930

18

YR

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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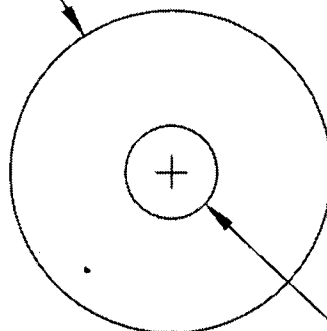
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2813	REV. A SHEET 1 OF 1
DATE 00.11.03		TITLE WASHER	SCALE 1:1
A	00.11.03	NEW ISSUE	

RELEASED
00.11.13 *[Signature]*

Ø1.80



NOT TO BE USED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *69384*
2011-05-10

Ø0.516

MATERIAL: DELRIN OR TEFLON OR UHMW 0.063 THICK
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
THIS PART CAN BE MADE FROM D2551

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